

S236026



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6023-106
Job Sheet 191724



Part No: D6023-106

Job Qty: 30 pcs

Part Name: Crosstube Material

32 pcs
vm

NOV 29 2019

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 11/27/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	30 pcs		11/27/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	30 pcs		11/27/19	0.00	0.00	Packaging 2 - 1 - B4B		NOV 29 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		NOV 29 2019
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S236026



Part: D6023 - 106

Job No: 191724

Serial No/Batch: S236026

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19

Plex 3/7/19 7:39 AM dart.lavoie.chantal

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 18	30 pcs	11/27/19	0.00 0.00	QC 18 - 12	
				QC 18 - 14	
				QC 18 - 22	
				QC 18 - 25	
				QC 18 - 42	
				QC 18 - 48	
				QC 18 - 58	
				QC 18 - 61	
				QC 18 - 9	
140 Packaging 3-1 - Stock - B4B	30 pcs	11/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	

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NOV 29 2019

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	30 pcs	11/27/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - Issue P/O 48828 a) Extrude as per Dwg D6023 b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or Descriptions: QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength=66 ksi e) Material certification is required

- 110 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material certification is attached
 120 - (QC18 In-Coming Inspection Material), Ensure Material certification comply to Dwg D6023
 140 - (Identify as per dwg & Stock Location: HALL), LOCATION : EG003-HALL
 150 - (QC21- Final Inspection - Work Order Release)

DEC 07 2019

x30PCS

MAR 07 2019

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6023-106P	Crosstube Material	30 pcs (1 ea)	100-Purchasing	S236022

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6023-106P	30	0	0

Part Specifications

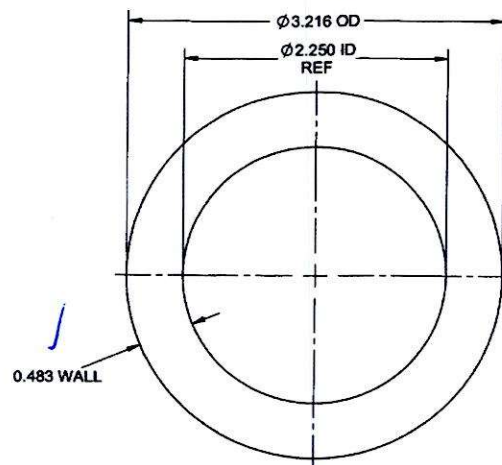
Specifications could not be found.

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Line 1

D6023-106

SPECIFICATION CONTROL DRAWING



D6023-XXX CROSSTUBE MATERIAL

WHERE XXX IS LENGTH IN INCHES.
EG. 106" LONG TUBE: D6023-106

NOTES:

1) MATERIAL: 3.216 OD X 0.483 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 KSI
MINIMUM YIELD TENSILE STRENGTH = 66 KSI

2) FINISH: NONE

3) TOLERANCES: PER ASTM B210 AS FOLLOWS:
O.D.: +/- 0.008 MEAN (+/- 0.016 INCLUDING OVALITY)
WALL: +/- 0.021 MEAN (+/- 0.048 INCLUDING ECCENTRICITY)
LENGTH: XXX +/- 0.188/-0.000

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED
2015-11-04
EN 5-692

A		NEW ISSUE		AP		15.10.13	
REV.		DESCRIPTION				BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	SHEET 1 OF 1
DRAWN	AP						
CHECKED	AJS	DRAWING NO. D6023				SCALE	
MFG. APPR.	JLM	TITLE				NTS	
APPROVED	WM	CROSSTUBE MATERIAL					
DE APPR.	DS						
DATE	15.10.13						

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042828



Supplier: KAI001-VU
Kaiser Aluminum
6573 W WILLIS ROAD
CHANDLER, AR 85226 USA
Phone: 520 796 1097
Fax: 520 796 0596

PO No: PO042828

PO Date: 3/7/19

Due Date: 11/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

MAILED
MAR 07 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: quote no. 664708

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191724	D6023-106P			Crosstube Material	Firmed	-	11/27/19	30 pcs	0 pcs	30 pcs	\$587.276/pcs	\$17,618.28
					EXTRUDE AS PER DWG D6023 REV. A MAT'L: 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) MIN. ULTIMATE TENSILE STRENGTH = 77 KSI MIN. TENSILE YIELD STRENGTH = 66 KSI					32 pcs Vn			

NOV 29 2019

Grand Total: \$17,618.28

Handwritten signature/initials



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042828



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 3/7/19 10:15 AM dart.lavoie.chantal

11/15/19

KAISER ALUMINUM FABRICATED PRODUCTS, LLC
PACKING LIST

PAGE 1

KAISER ALUMINUM
6573 W. WILLIS ROAD
BOX 5011
CHANDLER AZ 85226

SOLD TO

DART AEROSPACE LTD
HAWKESBURY

ON K6A 1K7

INSIDE SALES REP

FACIO

DART AEROSPACE LTD
1270 ABERDEEN
STREETBILL OF LADING
SHIP DATE
CARRIER
LOAD NUMBER
TOTAL GROSS WT235444
11/15/19
SAIA
PG17
1511 LBS.

SHIPMENT NBR- 229888 0001

HAWKESBURY ON K6A 1K7

SHIP ITEM	RELEASE	ITEM	DESCRIPTION	P.O. NUMBER	LOT NUMBER	PACKAGE NUMBER	PACK PIECES	GROSS WGT	NET WGT	FOOTAGE	BACK ORDER	INHOUSE DATE
1	229888	001	SPRIT-401772 YOUR PART#: D6023-106P 51822 5.0262#/FT 4000 7075 T6511 106 IN +.1880 -.0000 TOL	COMPLETE 42828	*51822-001 Dash 0001	M000177790	10 10	469	444		88.33	
2					51822-001 Dash 0001	M000177791	10 10	469	444		88.33	
3					51822-001 Dash 0001	M000177792	10 10	469	444		88.33	
4					51822-001 Dash 0001	M000177796	2 2	104	89		17.67	
TOTAL:								32	1511	1421	282.66	
TOTAL NET WT									1421	FOOTAGE	282.66	

AMS QQ-A-200/11

* MATERIAL CERTIFICATION REQUIRED FOR THIS LOT NUMBER.



Canada Customs
and Revenue Agency

Agence des douanes
et du revenu du Canada

CANADA CUSTOMS INVOICE
FACTURE DES DOUANES CANADIENNES

Page 1 of 1

1. Vendor (name and address) - Vendeur (nom et adresse) KAISER ALUMINUM FABRICATED PRODUCTS, LLC 6573 W. WILLIS ROAD CHANDLER, AZ 85226		2. Date of direct shipment to Canada - Date d'expédition directe vers le Canada 11/15/2019	
4. Consignee (name and address) - Destinataire (nom et adresse) DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7		5. Purchaser's name and address (if other than consignee) Nom et adresse de l'acheteur (s'il diffère du destinataire) 42828	
8. Transportation: Give mode and place of direct shipment to Canada Transport : Précisez mode et point d'expédition directe vers le Canada SAIA		9. Conditions of sale and terms of payment (i.e. sale, consignment shipment, leased goods, etc.) Conditions de vente et modalités de paiement (p. ex. vente, expédition en consignation, location de marchandises, etc.) USA	
11. BOI 235444 Number of packages Nombre de colis 4		12. Description of goods (kind of packages, marks and numbers, general description and characteristics, i.e., grade, quality) Désignation des articles (nature des colis, marques et numéros, description générale et caractéristiques, p. ex. classe, qualité) 3.2160 X 2.2500 X 0.4830 ROUND (HA ESRT) PART#: D6023-106P 7608.20.0030	
13. Quantity (state unit) Quantité (précisez l'unité) 1421		14. Unit price Prix unitaire 13.225	
15. Total 18792.42		16. Total weight - Poids total Net 1421	
17. Invoice total Total de la facture 18792.42		18. If any of fields 1 to 17 are included on an attached commercial invoice, check this box Si tout renseignement relativement aux zones 1 à 17 figure sur une ou des factures commerciales ci-attachées, cochez cette case Commercial Invoice No. / N° de la facture commerciale	
19. Exporter's name and address (if other than vendor) Nom et adresse de l'exportateur (s'il diffère du vendeur)		20. Originator (name and address) - Expéditeur d'origine (nom et adresse)	
21. CCRA ruling (if applicable) - Décision de l'Agence (s'il y a lieu)		22. If fields 23 to 25 are not applicable, check this box Si les zones 23 à 25 sont sans objet, cochez cette case	
23. If included in field 17 indicate amount: Si compris dans le total à la zone 17, précisez : (i) Transportation charges, expenses and insurance from the place of direct shipment to Canada Les frais de transport, dépenses et assurances à partir du point d'expédition directe vers le Canada (ii) Costs for construction, erection and assembly incurred after importation into Canada Les coûts de construction, d'érection et d'assemblage après importation au Canada (iii) Export packing Le coût de l'emballage d'exportation		24. If not included in field 17 indicate amount: Si non compris dans le total à la zone 17, précisez : (i) Transportation charges, expenses and insurance to the place of direct shipment to Canada Les frais de transport, dépenses et assurances jusqu'au point d'expédition directe vers le Canada (ii) Amounts for commissions other than buying commissions Les commissions autres que celles versées pour l'achat (iii) Export packing Le coût de l'emballage d'exportation	
25. Check (if applicable): Cochez (s'il y a lieu): (i) Royalty payments or subsequent proceeds are paid or payable by the purchaser Des redevances ou produits ont été ou seront versés par l'acheteur (ii) The purchaser has supplied goods or services for use in the production of these goods L'acheteur a fourni des marchandises ou des services pour la production de ces marchandises			

Dans ce formulaire, toutes les expressions désignant des personnes visent à la fois les hommes et les femmes.

KAISER ALUMINUM

FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CUSTOMER PO NUMBER: 42828-1		CUSTOMER PART NUMBER: D6023-106P		PRODUCT DESCRIPTION: 3.2160 X 2.2500 X 0.4830 ROUND (HA ESRT)	
KAISER ORDER NUMBER: 229888	LINE ITEM: 001	SHIP DATE: 11/15/2019	KAISER LOT NUMBER: 51822-001	ALLOY: 7075	TEMPER: T6511
WEIGHT SHIPPED: 1421.000 LB	QUANTITY: 32.000 PCS	B/L NUMBER: 235444	DIAM/DAF/THKNS:	WIDTH:	LENGTH: 8.833 FT
SHIP TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA			SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CON% IACS	BEND
51822-001	0001	0001	86.9	80.3	14.0	N/A	N/A	N/A
51822-001	0001	0002	87.9	81.2	14.5	N/A	N/A	N/A
51822-001	0001	0003	87.2	80.2	15.0	N/A	N/A	N/A
51822-001	0001	0004	87.5	80.9	15.5	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	NA	NA	NA	0.05	0.15
Minimum	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	NA	NA	NA	0.00	0.00
44049	.08	.15	1.54	.02	2.40	.19	5.77	.04	.00	.00	.02	.01	.02

Applicable Requirements:

Description: OD: 3.2160"+0.0160, -0.0160 IR ; Wall: 0.4830"+0.0480, -0.0480 IR ; Round (HA ESRT) @

AMS QQ-A-200/11

No Weld Repair. Mercury Free.

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

Plant Serial: 00033246
Kaiser Order Number: 229888
Line Item: 001

KAISER
ALUMINUM
FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Nathaniel Stevens, Quality Manager



Plant Serial: 00033246

Kaiser Order Number: 229888

Line Item: 001

EXTRUSION INSPECTION SHEET

ULTRA SONIC MEASUREMENTS

TUBE	#	TOTAL	SIDE A				SIDE B				Measurement unit Inches	Symbol		
			DIA		R2		R1		R2				R1	
			DIA	R2	DIA	R2	DIA	R1	DIA	R1				
	DWG													
1	106"	3.229	3.217	3.223	3.223	3.225	4.81	4.77	0.002	N/A	Middle	LOCATION	R1	
2	106"	3.235	3.221	3.224	3.221	4.250	4.94	4.81	0.002	N/A	Middle	R1		
3	106"	3.230	3.230	3.223	3.220	4.260	4.75	4.79	0.002	N/A	Middle	R1		
4	106"	3.238	3.226	3.227	3.221	4.256	4.81	4.79	0.003	N/A	Middle	R1		
5	106"	3.218	3.227	3.224	3.221	4.252	4.81	4.75	0.003	N/A	Middle	R1		
6	106"	3.220	3.218	3.227	3.226	4.261	4.90	4.83	0.004	N/A	Middle	R1		
7	106"	3.224	3.223	3.232	3.222	4.259	4.79	4.80	0.005	N/A	Middle	R1		
8	106"	3.229	3.223	3.222	3.218	4.262	4.87	4.84	0.008	N/A	Middle	R1		
9	106"	3.225	3.230	3.228	3.225	4.249	4.88	4.80	0.004	N/A	Middle	R1		
10										N/A	Middle			
11										N/A	Middle			
12										N/A	Middle			
13										N/A	Middle			
14										N/A	Middle			
15										N/A	Middle			
16										N/A	Middle			

5236622

P0 042828

D6023-106

Notes:

BATCH #

P/O#

PART #

Rockwell

Strightness at

12" in middle

Reading

N/A

Middle

LOCATION

R1

R2

R3

R4

on tube

N/A

Middle

LOCATION

R1

R2

R3

R4

on tube

N/A

Middle

LOCATION

R1

R2

R3

R4

on tube

N/A

Middle

LOCATION

R1

R2

R3

R4

on tube

N/A

Middle

LOCATION

R1

R2

R3

R4

on tube

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6023-106
DATE: NOV 29 2019

PO / BATCH NO.: P0042828/
5236022

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 32 pcs
QUANTITY INSPECTED: 32 pcs
QUANTITY REJECTED: -

THICKNESS ORDERED: .483" wall
THICKNESS RECEIVED: .483" wall
SHEET SIZE ORDERED: -
SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	Y ☒ N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	Y ☒ N	
CORRECT MATERIAL PER M-DRAWING	Y ☒ N	<u>AMS QQ-A-200/1</u>
CORRECT THICKNESS	Y ☒ N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	Y ☒ N	<u>HT: 51822-001-0001</u>
CORRECT MATERIAL IDENTIFICATION	Y ☒ N	
CORRECT M# ON THE MATERIAL	Y ☒ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>[Signature]</u>	DAS 81 9-89	SIGNED OFF BY: _____	
DATE: <u>NOV 29 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in